

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023675**Date Inspected:** 18-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Structure**Summary of Items Observed:**

During the Quality Assurance Magnetic Particle Testing (MT) review of welds located on AP3009 and AP3008, this Quality Assurance Inspector Manuel Teall discovered the following two (2) issues:

-One base metal Longitudinal Linear Indication (LLI) measuring approximately 6mm in length.

-The weld is identified as AP3009-051.

-The indication is located in the heat affected zone of the weld joining the Stiffener Plate to the Anchorage Plate.

-The Anchorage Plate is a Seismic Performance Critical Member (SPCM).

-The LLI was excavated to approximately 3mm into the base metal and re-examined using the Magnetic Particle Test (MPT) method until the LLI was removed.

-One Transverse Linear Indication (TLI) measuring approximately 7mm in length.

-The weld is identified as AP3008-048.

-The weld is a Complete Joint Penetration (CJP) groove weld with a 6 mm reinforcing fillet weld joining the Stiffener Plate to the Anchorage Plate.

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-The weld is designated as a Seismic Performance Critical Member (SPCM).

-The TLI was excavated to approximately 3mm and re-examined using the Magnetic Particle Test (MPT) method until the TLI was removed.

The Notice of Witness Inspection Number (NWIT) is 08568. The LLI and the TLI were located within an area previously tested and accepted by ZPMC Quality Control (QC) personnel. As per the contract documents, ZPMC's QC personnel are required to perform 100% inspection of the welds and adjacent base metal.

For further information, please see the attached pictures below.

### VISUAL INSPECTION

This QA Inspector Manuel Teall performed a random visual inspection on OBG APBB1-Bearing Blocks .the blocks are located in Bay 14 And in the paint bay .All visual defects were marked and ZPMC QC was notified .

#### Summary of Conversations:

No relevant conversations were reported on this date.

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Teall,Manuel	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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